

Date: Thursday, 06/11/2008 2:31:45 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: INNER FWD SADDLE
Job Number	: 43247		
Estimate Number	: 11079		
P.O. Number	:	Part Number	: D5953
This Issue	: 06/11/2008 S.O. No. :	Drawing Number	: D5953 REVB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 39794	Material	:
Written By	:	Due Date	: 27/11/2008 Qty: 6 Um: Each
Checked & Approved By	: <i>JLD 08-11-08</i>		
Comment	: Est Rev:E Re-Format 05-11-29 JLM Est Rev:f ecn 826 06.12.06 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 D6101-007(7075-T7351)
 Size 2.50" x 7.50" X 8.25" (Grain along 7.50")
 Batch: *B41960*

mk 08/11/08

⑥

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
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Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5953, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

mk 08/11/08

⑥

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

mk 08/11/10

⑥

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F.

08/11/20

⑥

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

M-L

08/11/22

⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 06/11/2008 2:31:46 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER FWD SADDLE

Job Number: 43247

Part Number: D5953

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

POWDER COATING

POWDER COATING



M109152



(6X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:00
320 °C
8:30

M-L 08/11/24

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



MS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-24 (X6)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PC 8/11/24 (6)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/26 (4)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



umf 08-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43247
Description: Inner Fwd Saddle		Part Number: D5953
Inspection Dwg: D5953	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.280	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.249	5.249	5.249	5.248		
F	4.745	4.755		4.748	4.748	4.748	4.749		
G	0.315	0.322		.321	.321	.321	.320		
H	1.522	1.532		1.528	1.528	1.528	1.528		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.579	4.579	4.579		
K	0.313	0.318		.321	.321	.321	.320		
L	0.495	0.505		.498	.499	.499	.499		
M	0.490	0.510		.502	.502	.502	.501		
N	1.615	1.635		1.631	1.632	1.633	1.633		
O	7.990	8.010		7.998	7.998	7.999	7.999		
P	2.240	2.260		2.258	2.260	2.259	2.259		
Q	0.307	0.312		.310	.310	.310	.310		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.500	.502	.502	.502		
T	1.375	1.395		1.387	1.387	1.388	1.388		
U	2.000	2.020		2.001	2.010	2.009	2.010		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>mf</i>
Date: 05/11/10

Audited by: J-F
Date: 08/11/20

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	

DART AEROSPACE LTD		Work Order: 43247
Description: Inner Fwd Saddle		Part Number: D5953
Inspection Dwg: D5953	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1.40	1.40	86	77		
A	0.438	0.443				.440	.440		
B	1.745	1.755				1.750	1.749		
C	5.245	5.255				5.250	5.250		
D	6.995	7.005				7.000	7.000		
E	5.240	5.260				5.249	5.249		
F	4.745	4.755				4.749	4.748		
G	0.315	0.322				.321	.321		
H	1.522	1.532				1.526	1.528		
I	3.048	3.058				3.052	3.053		
J	4.575	4.585				4.580	4.579		
K	0.313	0.318				.321	.321		
L	0.495	0.505				.499	.498		
M	0.490	0.510				.502	.502		
N	1.615	1.635				1.634	1.632		
O	7.990	8.010				8.000	8.000		
P	2.240	2.260				2.258	2.258		
Q	0.307	0.312				.310	.310		
R	0.760	0.765				.760	.760		
S	0.490	0.510				.500	.503		
T	1.375	1.395				1.388	1.385		
U	2.000	2.020				2.008	2.008		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

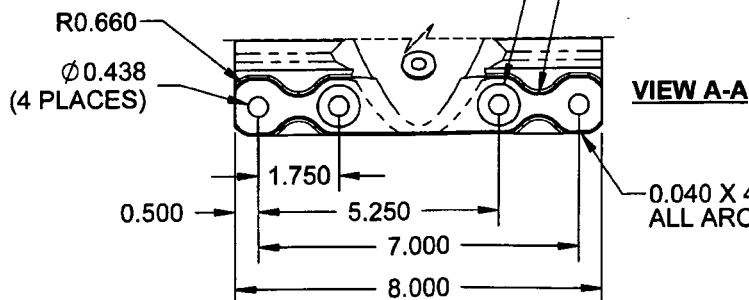
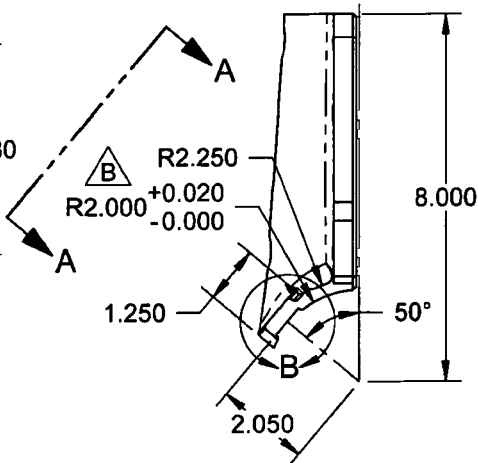
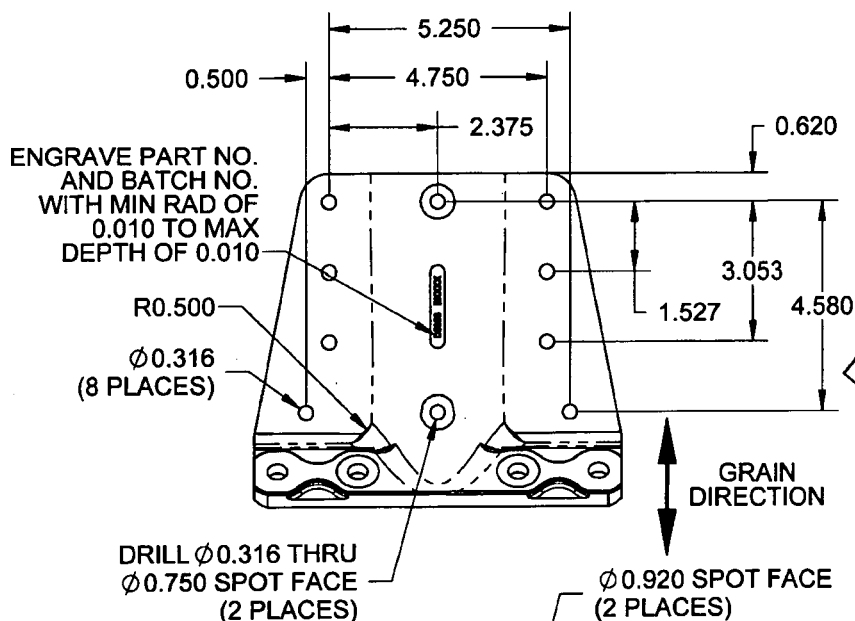
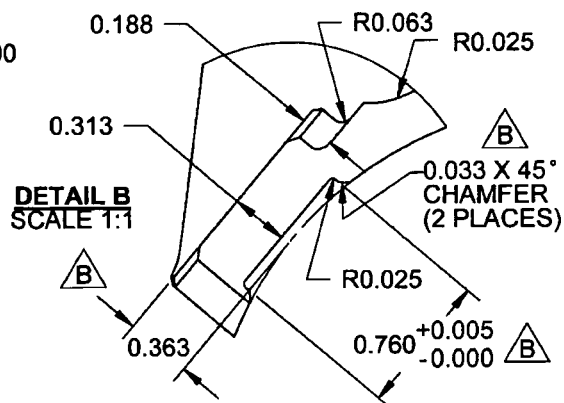
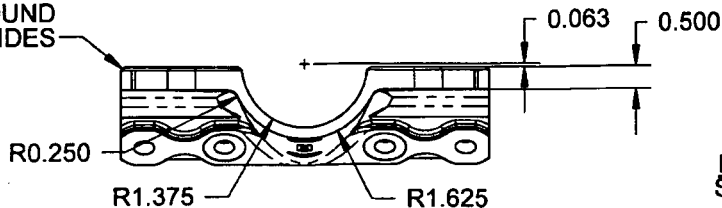
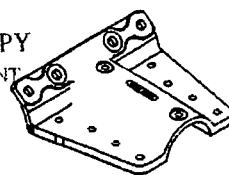
Measured by: <i>ML</i>
Date: 08/11/20

Audited by: J.F.
Date: 08/11/20

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5953	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE INNER FWD SADDLE		SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

RELEASED
06.11.28CHAMFER
0.075 X 45°
ALL AROUND
BOTH SIDES**D5953 INNER FWD SADDLE**SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **43247****ISOMETRIC VIEW**
SCALE 1:8**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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